Fusion3

# F200 3D Printer

## REPAIR:
## EXTRUDER REPLACEMENT

Revision 5/16/2025

# REPLACING THE EXTRUDER

## BEFORE YOU BEGIN

Your printer should be off and cold.

Unload filament if possible.

Estimated repair time: 15 minutes.

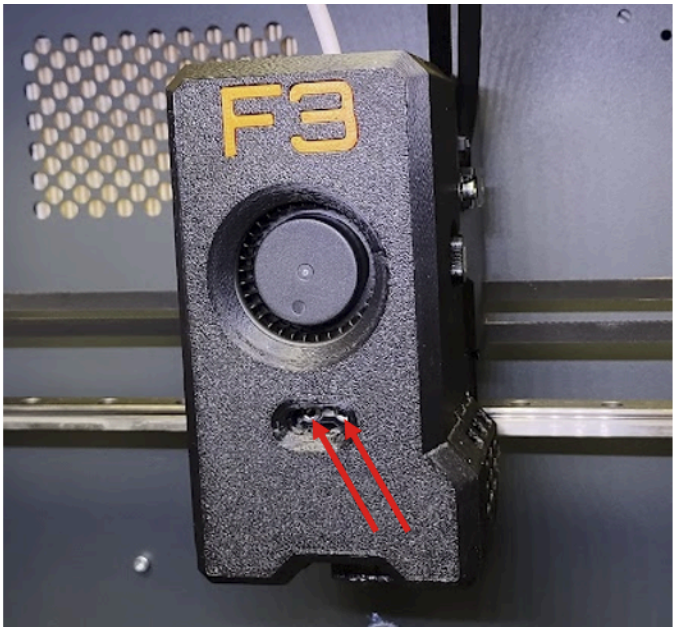
Tools required:

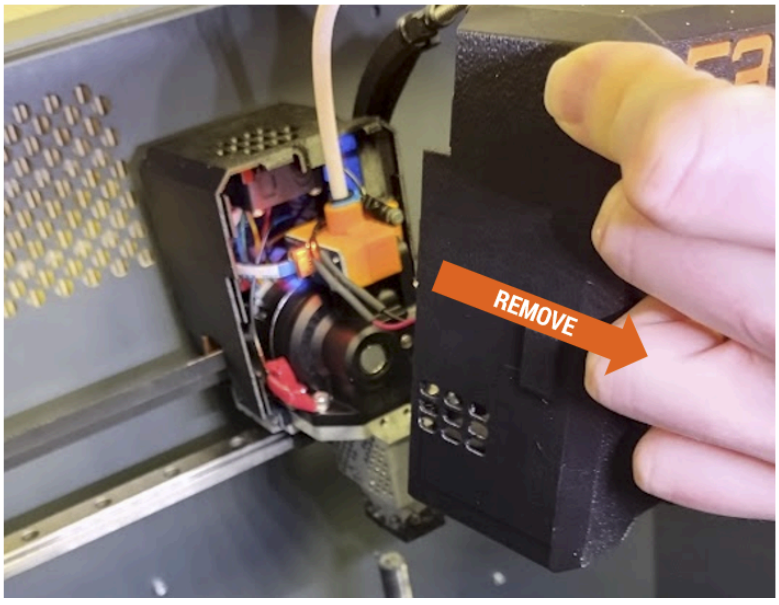
- 2.5mm hex drive
- 1.5mm hex drive
- Black stick or other gentle prying tool (NOT metal)

NOTE: Some of these pictures were taken on a pre-production printer and your printer will look slightly different.

## REMOVAL

1. Remove the front toolhead housing.




2. Remove the filament monitor.

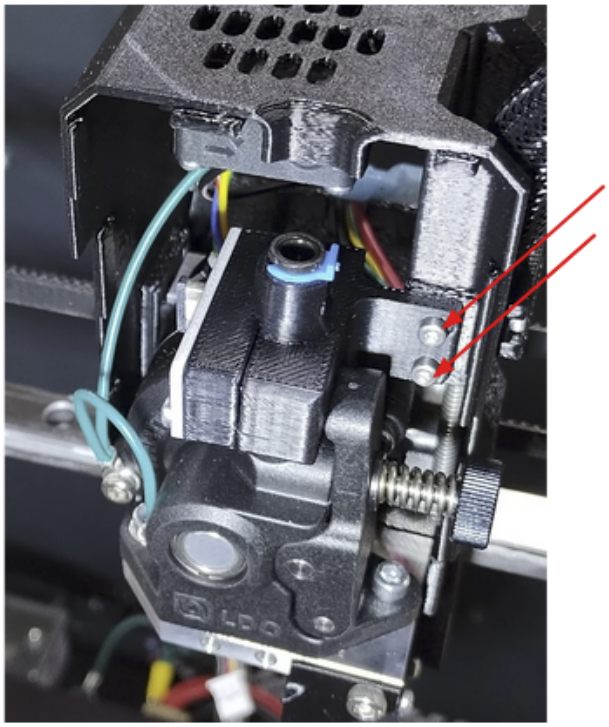
a. Use your prying tool to open and remove the ZIF connector and ribbon cable so it does not become damaged. See HERE for more information on working with these small ZIF connectors.

CLOSED CONNECTOR

OPEN CONNECTOR

b. 2x M2x6 SHCS

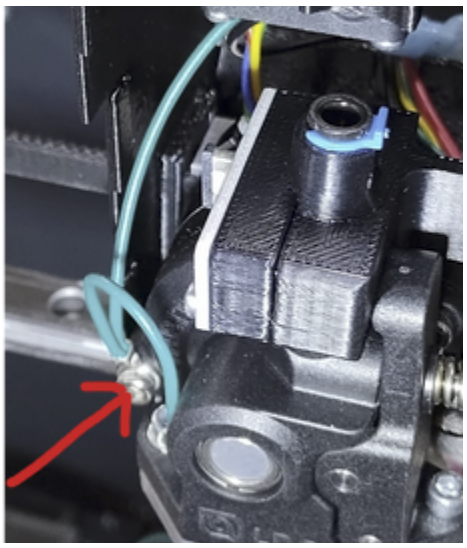
c. You can leave the PTFE tube on the inlet connected.



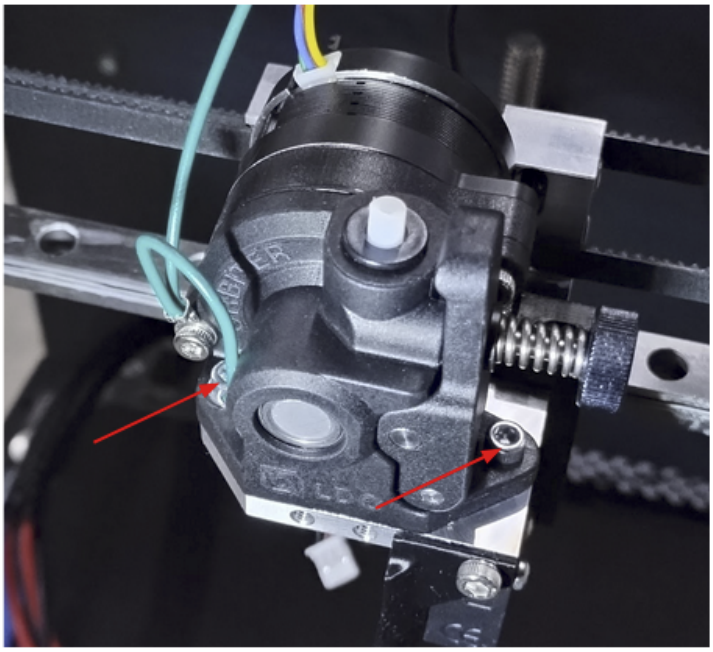
3. Remove the extruder grounding wire on the extruder body.

a. 1x M3x?? SHCS

b. Remove the screw, remove the ring terminal, and put the screw back into the extruder.



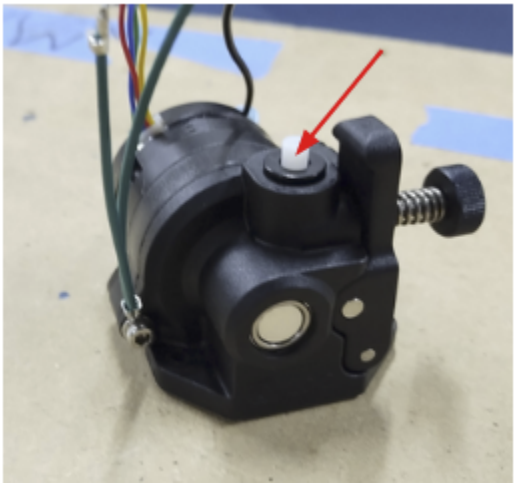
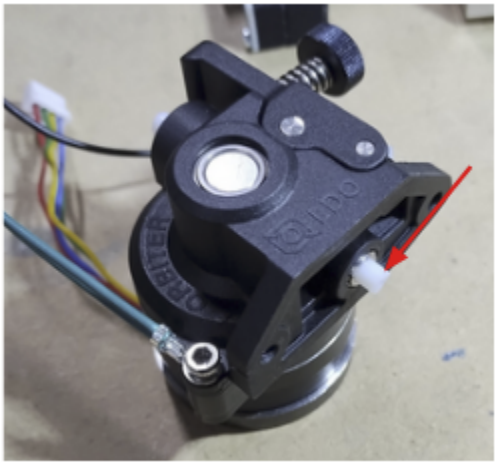
4. Remove the 2 screws holding the extruder to the base plate
    a. 2x M3x10 SHCS
    b. The left screw has a ground wire on it, this stays with the printer.



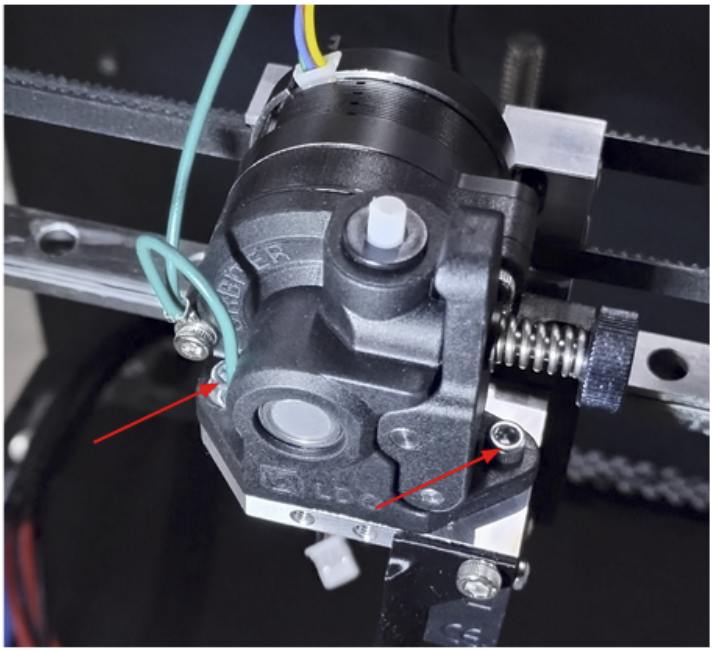
5. Slide the extruder out of the toolhead.

## INSTALLATION

1. Verify the top and bottom liners are in place.  These will be held in place with blue tape and the blue tape needs to be removed prior to installation.

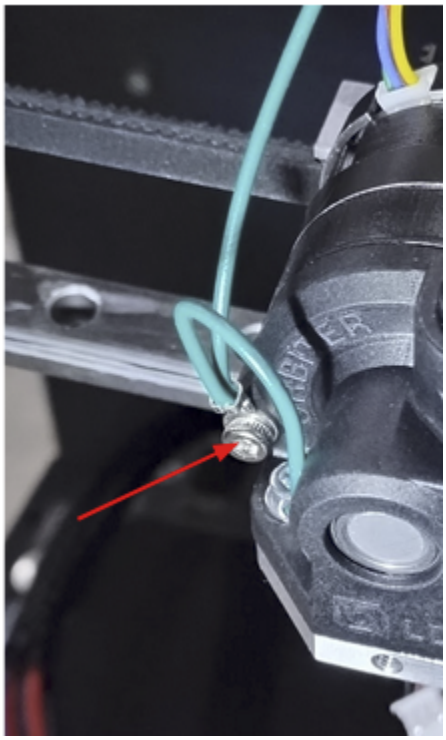



2. Slide the extruder into place.
    a. You should feel the lower liner drop into the hole in the base plate.
3. Install the mounting screws
    a. 2x M3x10 SHCS
    b. The left screw gets the ground wire ring terminal.



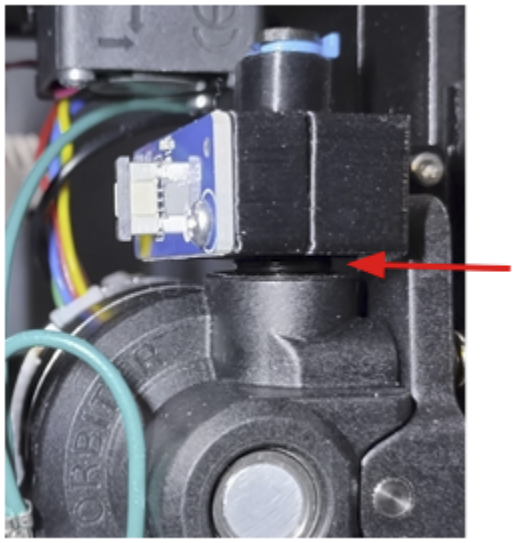
4. Install the ground wire
    a. Remove the left extruder body screw (M3x?? SHCS), install the ring terminal, and reinstall the screw.

b. Finger tight + ¼ turn.

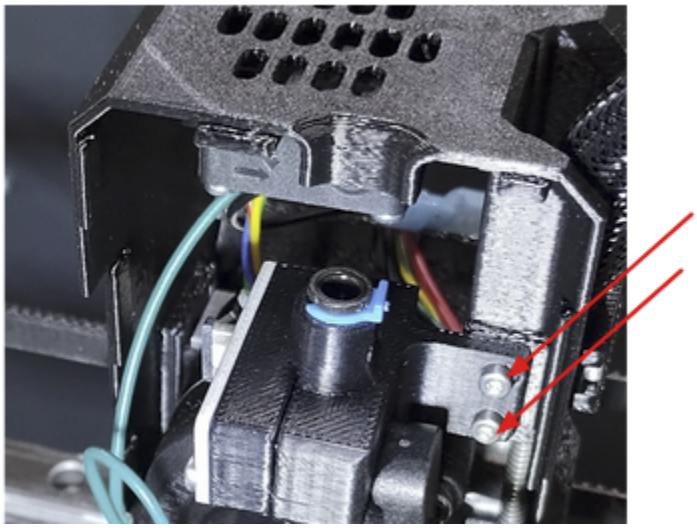


5. Install the filament monitor

a. Position it on the top liner.



b. Install the mounting screws (M2x4 or M2x6 SHCS)



c. Install the ribbon cable. See previously linked instructions for more info.

6. Reinstall the front toolhead housing.

## TESTING

1. Load filament as normal.
2. Run a print.

## STILL NEED HELP?

Contact our support team:

support@fusion3design.com

https://www.fusion3design.com/contact-support/

877-452-0010 x2